Page 1

PB67-43001-229 Item ID: Accept Setup Start **Revision ID:** Stop Outer Tube Item Name: **Start Date:** 12/16/09 Start Qty: 2.00 **Cust Item ID:** Required Date: 12/31/09 Req'd Qty: 2.00 **Customer:** Reference: Run Start **Tooling:** Approvais: **Process Plan:** Date: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Draw Draw Reject Plan Accept Reject Insp. Work Center ID Description Number Rev. Qty Qty Run Hours · Code Number Stamp **Draw Nbr Revision Nbr** BI B67-43001 100 0.00 **BAND SAW** Bandsaw 0.00 Memo Jeaspa Bandsaw 1- cut to length and cut angle on one end of tube as per dwg 2- deburr 110 0.00 CONVENTIONAL MILLING MACHINE Mill Conv 0.00 Memo Conventional Milling Machine 1- drill holes and mill slot as per dwg PB67-43001 2- deburr 120 QC5- Inspect part completeness to step on W/O 0.00 0.00 Memo **Quality Control**

Page 2

December 16, 2009 9:21:03 AM PB67-43001-229 Item ID: Accept Setup Start **Revision ID:** Stop Outer Tube Item Name: Start Qty: 2.00 **Start Date:** 12/16/09 **Cust Item ID:** Required Date: 12/31/09 **Req'd Qty: 2.00 Customer:** Reference: Run Start Process Plan: Date: **Tooling:** Approvals: Date: Stop Date:_____ **SPC (Y/N):** Date: Sequence ID/ Operation Set Up/ Reject Draw Draw Plan Accept Reject Insp. Work Center ID Description **Run Hours** Number Rev. Code Qty Qty Number Stamp 0.00 Large Fab Large Fab 0.00 Memo Large Fab 1-Weld end cap as per dwg PB67-43001 2- grind weld flush 140 QC10- Inspect visual per QSI004- ground welds 2) 510/01/04 OC Memo Quality Control 150 QC5- Inspect part completeness to step on W/O 0.00 Memo Quality Control

Work Order ID 54670

December 16, 2009 9:21:04 AM



Page 3

Item ID:

PB67-43001-229

Accept

Setup Start



Revision ID:

Outer Tube Item Name:

Required Date: 12/31/09

12/16/09

Start Qty: 2.00

Req'd Qty: 2.00

Cust Item ID: Customer:

Reference:

Start Date:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Draw

Number

Run

Start

Stop

Stop



QC:

Date:

SPC (Y/N):

Date:

Reject Reject

Insp.

Sequence ID/ **Work Center ID**

160

Packaging

Operation Description

Identify as per dwg & Stock Location:

Set Up/ **Run Hours**

0.00

Code

Plan

Draw

Rev.

Accept **Qty**

Qty Number

Stamp

Packaging

Memo

Memo

0.00

170

QC

QC21- Final Inspection - Work Order Release

0.00

0.00

Quality Control

V 10.01.05

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Picklist Print	, <i>y</i> ,								<u> </u>			Pa
December 16, 2009 9.	:21:02 AM											1 0
Work Order ID: 5467	0							AL 100				
	7-43001-229 Duter Tube							9	44-4 D-4 12/1	C/00	Dec to ID.	12/21/00
Comments:									tart Date: 12/1 Start Qty: 2.00		Required Date: Required Qty:	
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Stat
M6061T6T1.750W.065		Purchased	No			100	f	33.8200	10.7895			
6061T6 RDTUBE 1.750 X	0.65W			Wareho Loc	use ation	<u>Loc</u>	Oty	Loc Code	1055 C	do.	Effective	}
					arehouse							_
				MA	108551 109397 110885		33.82 2.24 0.4 16.69		 - -		- - -	

111432

PB67-43001-233 Manufactured

Outer Tube End Cap

Warehouse Loc Qty Loc Code Location Main Warehouse ST 41573

130

14.49

Each

7.0000

2.0000

Ell coss who attached

Page 1

Status

120

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

0.00

Dart Aerospa	ce Ltd
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Duit Ac	ospaoi	Liu								
W/O:				V	ORK ORDER CHANG	SES				f 7
DATE	STEP		PRO	OCEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:		PAR #:	Fault Ca	tegory:	NCR: Ye	s No D	QA:	Date: _	
	R	esolution:		Disposit	ion:	QA: N/C	Closed: _		Date: _	
NCR:				WORK OR	DER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Descri	ption of NC			tion B	Veri	fication	Approval	Approval
DAIL	SILF	Se	ection A	Initial Chief Eng	Action Description Chief Eng	on Description Sign & Section			Chief Eng	QC Inspector
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Work Order ID 47092



Page 2

December 11, 2009 8:58:16 AM

Required Date: 03/08/2009

Item ID:

PB67-43001-29

Accept

Setup Start

Stop



Revision ID: B1

Item Name:

Blade Positioner Weldment

Start Date:

15/07/2009

Start Qty: 2.90 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: Date:

Date:

Tooling:

Date:

Date:

Start

Run

Stop



Sequence ID/ **Work Center ID**

130

HandFinish Hand Finishing Operation Description

Chemical Conversion Coat per QSI005 4.1

Set Up/ **Run Hours** 0.00

SPC (Y/N):

Draw Number Draw Plan Rev. Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

140

Powdercoat

Powder Coating

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

0.00

0.00

Memo

Memo

START TIME:

□OVEN TEMPERATURE:

DFINISH TIME

150

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

									
W/O:			W	ORK ORDER CHANG	SES				ť f
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQ	A :	Date:	
	Re	esolution:	Disposit	ion:	_ QA: N/C CI	osed:	, 	Date: _	
NCR:		V	VORK OR	DER NON-CONFORM	ANCE (NCF	1)			
DATE	STEP	Description of NC			tion B		cation	Approval	Approval
	O.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sect	ion C	Chief Eng	QC Inspector
			·						
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				2					

Work Order ID 47092

Page 3

December 11, 2009 8:58:16 AM

Item ID:

PB67-43001-29

B1 **Revision ID:**

Required Date: 03/08/2009

Blade Positioner Weldment Item Name:

Start Date:

15/07/2009

Start Qty: 2.00

Req'd Qty: 2.00

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop



Sequence ID/ Work Center ID

160

Packaging

Operation Description

Identify as per dwg & Stock Location:____

Set Up/ Run Hours

0.00

Draw Number Draw Rev.

Plan Accept Qty Ćode

Reject Qty

Reject Number Stamp

Insp.

Packaging

Memo

Memo

0.00

170

QC

QC21- Final Inspection - Work Order Release

0.00

0.00

Quality Control

	-									•
W/O:			W	ORK ORDER CHAN	GES					· • • • • •
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cat	tegory:	NCI	R: Yes	No DQ	A :	_ Date: _	
·	Re	esolution:	Dispositi	ion:	QA	N/C CI	osed:		Date: _	
NCR:		\	WORK ORI	DER NON-CONFORM	IANCE	(NCR)		•	
DATE	STEP	Description of NC			ection B		Verifi	cation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	1	Sign & Date	Sect	ion C	Chief Eng	QC Inspector

										3
	1 .	,							1	

Picklist Print

December 11, 2009 8:58:20 AM

Work Order ID: 47092

Parent Item:

Comments:

PB67-43001-29RevB1

Parent Item Name: Blade Positioner Weldment

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Rerstaining Qty To Pick	Qty Issued	Date Issued	Status
PB67-43001-313RevB1		Manufactured	No		-	100	Each	0.0000	2.0000			
Plate PB67-43001-319RevB1		Manufactured	No			100	Each	0.0000	4.0000			
Gusset PB67-43001-337RevB1		Manufactured	No			100	Each	0.0000	4.0000	·		

Stop Plate

	ocpace.													
W/O:			WORK ORDER CHANGES											
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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Part No	:	PAR #:	Fault Cate	egory:	NCR: Ye	s No DO	QA:	Date:						
	Re	solution:	Disposition	on:	QA: N/C	Closed: _		Date: _						
NCR:			WORK ORE	ER NON-CONFORM	MANCE (N	CR)								
DATE	STEP	Description of NC			ection B		ication	Approval	Approval					
	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	n Sig Da		ction C	Chief Eng	QC Inspector					
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		W-1-404-4		N										
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December 11, 2009 8:59:08 AM

Work Order ID: 47092

Parent Item:

PB67-43001-29RevB1

Parent Item Name: Blade Positioner Weldment

Comments:



Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin \@@imary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remain Fag Qty To Pick	Qty Issued	Date Issued	Status
PB67-43001-313RevB1	### 11 11 1111 111 1 11 11	Manufactured	No		100	Each	0.0000	2.0000			
Plate PB67-43001-319RevB1		Manufactured	No		100	Each	0.0000	4.0000			
Gusset PB67-43001-337RevB1	### #8 ## ### ########################	Manufactured	No 		100	Each	0.0000	4.0000		· ·	

Stop Plate

W/O:			V	VORK OR	DER CH	ANGES	3				·	*
DATE	STEP	PROCI	EDURE CH	IANGE			E	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					•							
								,				
Part No	:	PAR #:	Fault Ca	itegory:			NCR:	Yes N	lo DQ	A:	Date:	
•	R	esolution:	Disposit	tion:		:	QA: N	/Ĉ Clo	sed:		Date: _	
NCR:	-	WC	ORK OR	DER NON	I-CONFC	RMAN	CE (NCR)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Correctiv Acti	e Action on Descrip Chief Eng	Section (otion	8	ign & Date	Verific Secti		Approval Chief Eng	Approval QC Inspector
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Qty:

Each

2 Um:

: OUTER TUBE

: PB6743001229

- B6743001 P.19

: 15/04/2009

: N/A

: B1

Date: User:

Wednesday, 08/04/2009 10:59:31 AM

Melanie Fauteux



Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

Job Number

: 47092

Estimate Number

: 13501

P.O. Number

: 08/04/2009

This Issue

: NC Prsht Rev.

: 1.1 First Issue : 45258 **Previous Run**

Written By

Checked & Approved By Comment

-: Est Rev:A

Type

new issue DD verified by:ec

: MACHINED PARTS

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

6061T6 RDTUBE 1.750 X 0.65W

10.7625 f(s)



Total: Comment: Qty.: 5.3813 f(s)/Unit

6061T6 RDTUBE 1.750 X Q.65W

batch:

BAND SAW

05/04/23

Comment: SMALL & MEDIUM FAB RESOURCE 1

1- cut to length and cut angle on one end of tube as per dwg

2- deburr

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- drill holes and mill slot as per dwg PB67-43001 USING DT8792

2- deburr

QC5

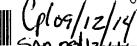
INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PB6743001233

Comment: Qty.:



Outer Tube Partial End Cap



Outer Tube Partial End Cap

1.0000 Each(s)/Unit

= 2 X



W/O:			WORK ORDER CHANGES									
DATE	STEP	PROCI	EDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
	2		•									
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Part No	*) +	PAR #:	Fault Category	/:	_ NCF	R: Yes N	lo DQ A	\:	Date:			
	Ŗ	esolution:	Disposition: _	(),	_ QA:	N/C Clos	sed:		Date: _			
NCR:	_ &	WC	ORK ORDER	NON-CONFORMA	NCE	(NCR)						
DATE	STEP	Description of NC Section A	Cor Initial Chief Eng	rective Action Section Action Description Chief Eng		Sign & Date	Verific Section		Approval Chief Eng	Approval QC Inspector		
										76		
				*: <u>.</u>					-			
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Date: Wednesday, 08/04/2009 10:59:31 AM User: 💃 Melanie Fauteux **Process Sheet** Drawing Name: OUTER TUBE Customer: CU-DAR001 Dart Helicopters Services Part Number: PB6743001229 Job Number: 47092 Job Number: Seq. #: **Description: Machine Or Operation:** LARGE FAB 1 LARGE FABRICATION RESOURCE 1 Comment: 1- bend end cap to fit on tube 2-Weld end cap as per dwg PB67-43001 3- grind weld flush VISUAL INSPECTION OF GROUND WELDS Comment: VISUAL INSPECTION OF GROUND WELDS INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 10.0 🔪 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion

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W/O:

W/O:											
DATE	STEP	.	PROC	CEDURE CHANGE		ا ا	Ву	Date.	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:	, '	W	ORK OR	DER NON-CONFORMANCE	(NCR)		*	
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification	Ammuoval	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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